

Date: Monday, 5/26/2008 1:09:52 PM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-350 AFT CANOPY		
Job Number	: 39497			Part Number	: D36561		
Estimate Number	: 13098			Drawing Number	: D3656 REV A		
P.O. Number	:			Project Number	: 00204		
This Issue	5/26/2008	S.O. No.	:	Drawing Revision	: A		
Prsht Rev.	: NC			Material	:		
First Issue	/: /	Type	: THERMOFORMING	Due Date	: 5/30/2008		
Previous Run	: 39494			Qty:	4	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 08.5.26</u>						
Comment	: Est. Rev. A 07/12/13 DL verified by:DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
Comment: Qty.: 32.0000 sf(s)/Unit Total : 128.0000 sf(s) GE PLASTICS LEXAN SHEET batch: <u>105494</u>		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING 1) Cut Blanks to fit frame size		
3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE Thermoform as per Dwg. D3656-1 and Folio FTA 015 using tool DT 8986		
Dwg. Rev. <u>A</u> Folio Rev. <u>A</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE Visually inspect for proper formation of each part		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D36Sb-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 20/06/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 39497		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.06.12	3	2 parts did not form properly due to machine. RC: Peter house keepin' recip	BS QSPC2	Scrap & replace parts clean infrared eye.	08.06.12 WV	S 08/06/20	BS 03/07/12	C 08/06/20
08.06.12	3.	2 parts not formed. Too much moisture in sheet.	BS QSPC2	Scrap & replace parts. dry sheets prior to using.	08.06.12 WV	S 08/06/20	BS 03/07/12	C 08/06/20
		PC: New Development						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 AFT CANOPY

Job Number: 39497

Part Number: D36561

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK 
6.0	HAND FINISH TH	HAND FINISHING THERMOFORMING 
	Comment: HAND FINISHING THERMOFORMING	
	1) Trim to Finished Dimensions as per dwg D3656	08/06/16
7.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
	Check dimensions to ensure conformity to drawing tolerances.	08/06/16
8.0	QC5	INSPECT WORK TO CURRENT STEP 
	Comment: INSPECT WORK TO CURRENT STEP	08/06/16
9.0	PACKAGING 1	PACKAGING RESOURCE #1 
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PPP 39941	08/06/16
10.0	QC21	FINAL INSPECTION/W/O RELEASE 
	Comment: FINAL INSPECTION/W/O RELEASE	08/06/16
	Job Completion	

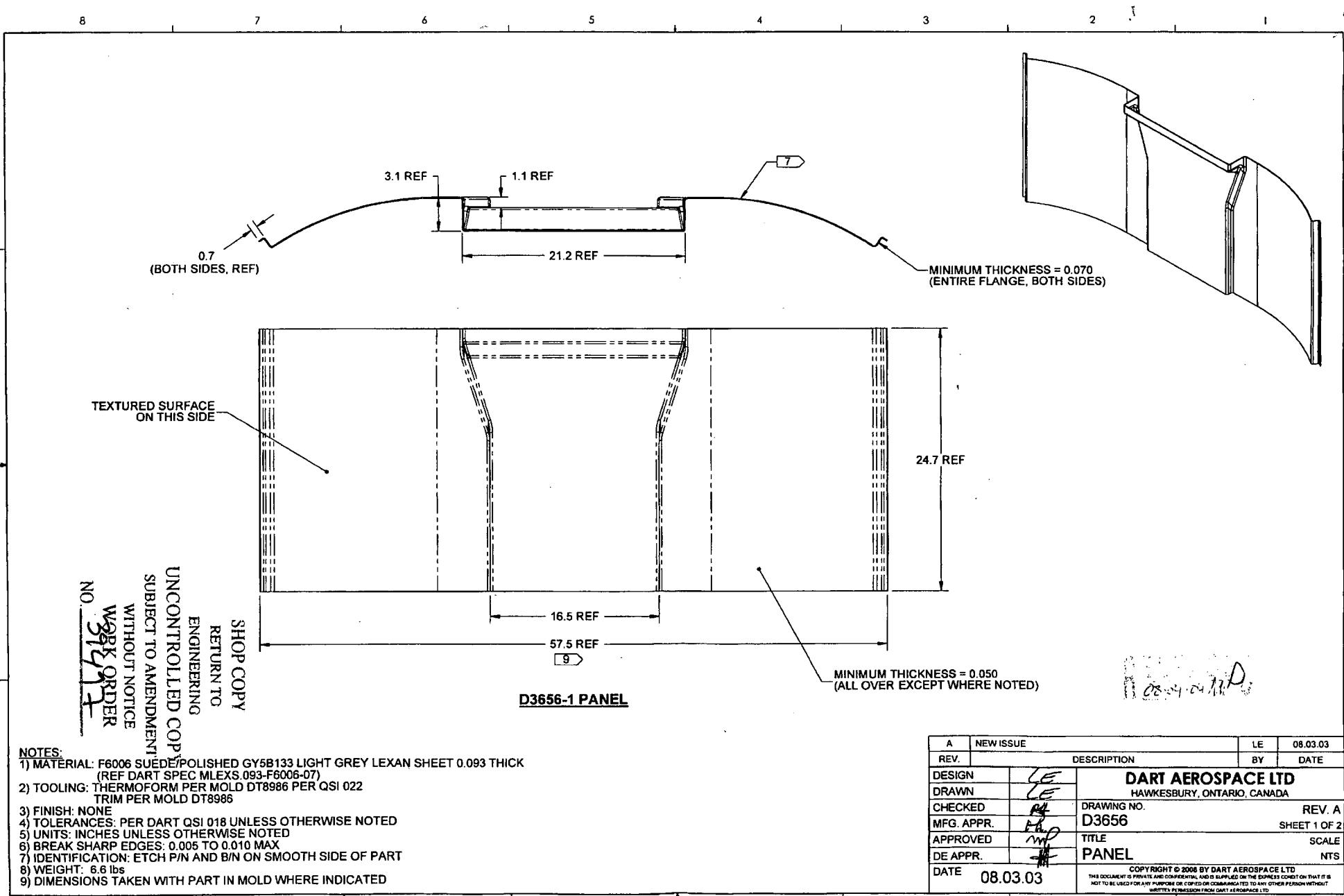
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

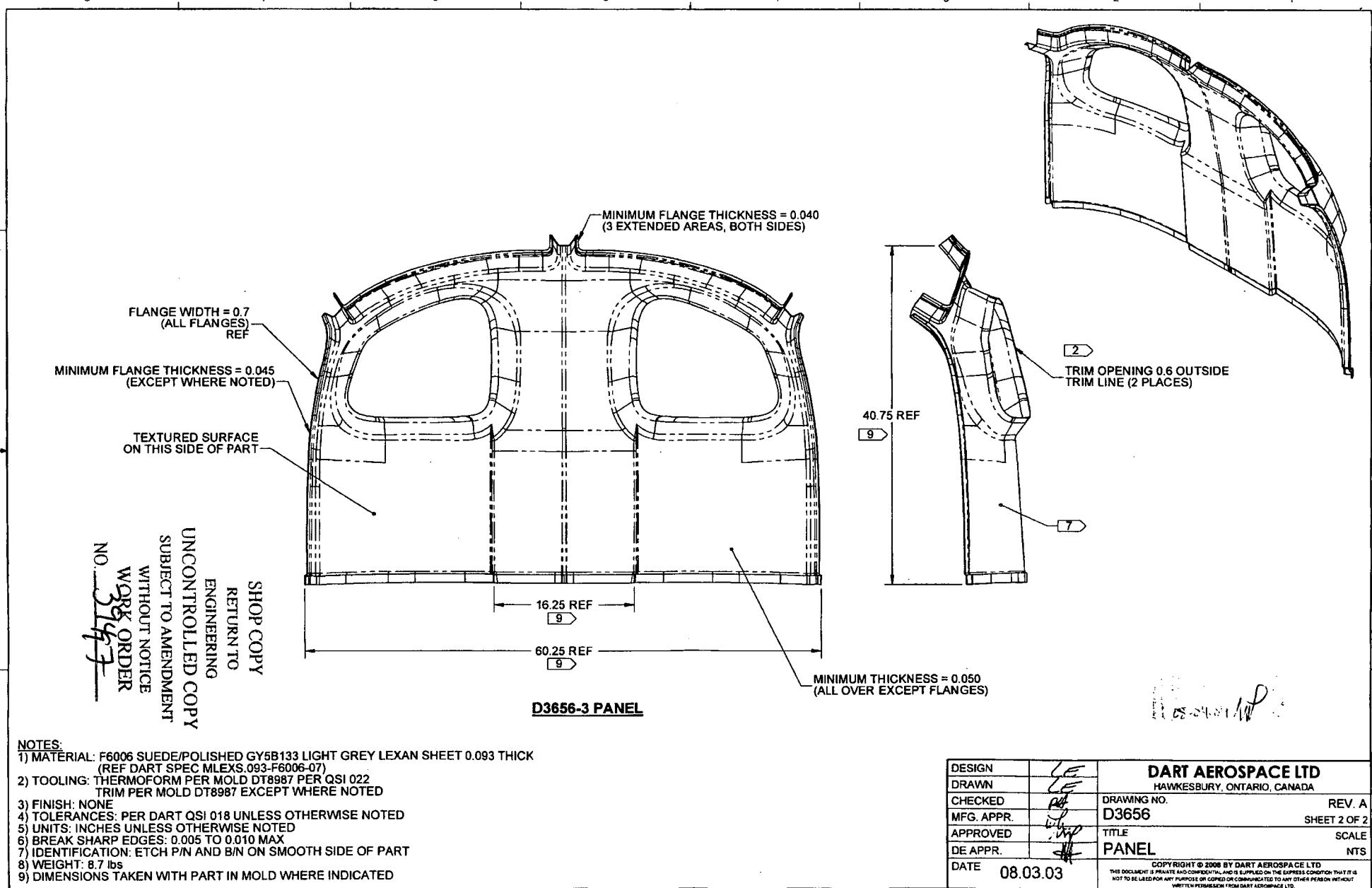
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



A	NEW ISSUE	LE	08.03.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE		
DRAWN	LE		
CHECKED	RE		
MFG. APPR.	LE		
APPROVED	MP		
DE APPR.	RE		
DRAWING NO.	D3656	REV. A	
		SHEET 1 OF 2	
TITLE	PANEL	SCALE	NTS
DATE	08.03.03		

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DESIGN	<i>EE</i>	DART AEROSPACE LTD
DRAWN	<i>EE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BB</i>	DRAWING NO. <b>D3656</b> REV. A
MFG. APPR.	<i>WIP</i>	SHEET 2 OF 2
APPROVED	<i>WIP</i>	TITLE <b>PANEL</b> SCALE <b>NTS</b>
DE APPR.	<i>WIP</i>	DATE <b>08.03.03</b>

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DART AEROSPACE LTD	WORK ORDER:	39457
Description: Aft Canopy	Part Number:	D3656-1
Inspection Dwg:	Rev: A	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

First Article  Prototype

#### (Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

## (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Measured by: <u>BB</u>	Audited by: <u>  </u>	Prototype Approval: <u>  </u>
Date: <u>08/06/16</u>	Date: <u>08/06/16</u>	Date: <u>  </u>

Rev	Date	Change	Revised by	Approved by
		New Issue		

DART AEROSPACE LTD	WORK ORDER:	39487
Description: Aft Canopy	Part Number:	1 D3656-1
Inspection Dwg:	Rev: A	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

#### (Step 4) Thermoforming Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	B.P.
Free of visual flaws (bumps, cracks, voids, etc.)	B.F.

## (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_ and record below

Measured by: <u>BS</u>	Audited by: <u>J</u>	Prototype Approval: <u>✓</u>
Date: <u>08/06/16</u>	Date: <u>08/06/16</u>	Date: <u>08</u>

Rev	Date	Change	Revised by	Approved by
		New Issue		

DART AEROSPACE LTD	WORK ORDER:	39497
Description:Aft Canoy	Part Number:	2. D3656-1
Inspection Dwg:	Rev: A	Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

First Article  Prototype

## (Step 4) Thermoforming Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	Y
Free of visual flaws (bumps, cracks, voids, etc.)	Y

## (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing \_\_\_\_\_ Rev. \_\_\_ and record below

Measured by: <u>BS</u>	Audited by: <u>J</u>	Prototype Approval: <u>n/a</u>
Date: <u>08/06/16</u>	Date: <u>06/06/17</u>	Date: <u>06/06/17</u>

Rev	Date	Change	Revised by	Approved
		New Issue		

DART AEROSPACE LTD	WORK ORDER:	39497	
Description:Aft Canoy	Part Number:	3 D3656	-1
Inspection Dwg:	Rev: A	Page 1 c	

## FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

## (Step 4) Thermoforming Visual Inspection Sign-off

Description	Initial
Acceptable shape definition	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

## (Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing Rev. and record below

Measured by: B.D  
Date: 08/06/16

Audited by:	✓
Date:	08/06/17

Prototype Approval: u / b  
Date:

Rev	Date	Change	Revised by	Approved by
		New Issue		